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single-tier normal dryer groups, each of said plurality of normal dryer groups including a single tier of dryer cylinders, a plurality of suction guide rolls disposed below and between said dryer cylinders, and a single wire transporting said web over the dryer cylinders and beneath the guide rolls so that only the bottom side of said web engages said dryer cylinders; and

subsequently applying sufficient heat and moisture to the asymmetrically dried paper web to relax said stresses in the fiber mesh of the paper web, to thereby control curling of the web.--

--34. A paper machine, comprising:

a dryer for asymmetrically drying a paper web in its thickness direction extending between the top and bottom sides of the paper web to a solids content at which curl-inducing stresses are formed in the paper web, said dryer including a plurality of top-felted single-tier normal dryer groups, each of said plurality of normal dryer groups including a single tier of dryer cylinders, a plurality of suction guide rolls disposed below and between said dryer cylinders, and a single wire transporting said web over the dryer cylinders and beneath the guide rolls so that only the bottom side of said web engages said dryer cylinders; and

a device for applying heat and moisture to the asymmetrically dried paper web for relaxing said stresses to thereby control curling of the web.--

--39. The paper machine of claim 34, wherein said stresses in said fiber mesh of the paper web are formed at a solids content of at least about 70%.--